

Date: Thursday, 05/02/2009 3:44:18 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206B BASKET LID - UNDER REVIEW
 Job Number : 45545A
 Estimate Number : 10690
 P.O. Number :
 This Issue : 05/02/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LARGE FAB ASSY
 Previous Run : 31456A
 Part Number : D2330043
 Drawing Number : D2330 UNDER REVIEW
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 28/02/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JUD 09.02.06
 Comment : Est Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K
 J

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TS0750W065

304 SQ Tube .75x.75x.065W



Comment: Qty.: 23.3625 f(s)/Unit Total: 23.3625 f(s)
 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: M111/48

END BAR Scrap 47" inch

JUD 09/04/06

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Cut D2330-1-3-9 as per Dwg D2330

2-Drill hole in D2330-3 as per Dwg D2330

3-Deburr

Scrap

JUD 09/04/06

3.0

D2329

Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2329 Label Plate

4.0

D2327-3 ok

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-3 Bushing

D2327-3

ok

B46325

JUD 09/04/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:44:18 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID - UNDER REVIEW

Job Number: 45545A

Part Number: D2330043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Chanel

6.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)

Pick:

Qty Part Number Description Batch

18 sf M304EX0.75-16F Expanded Metal

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner Jig

Deburr as required

A/R SS ROD Batch: _____

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID - UNDER REVIEW

Job Number: 45545A

Part Number: D2330043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -043	PART NUMBER	
X		D2330-041	B
	X	D2330-043	L
1		D2012-107	C
	2	D2232-1	H
2		D2232-3	H
4		D2235-1	R
2		D2253-1	L
2		D2254	G
	1	D2327-1	B
1		D2327-3	B
	1	D2329	L
2		D2330-1	F
2	2	D2330-3	F
1		D2330-5	F
1		D2330-7	F
1	2	D2330-9	F
	2	D2330-11	F
	2	D2330-13	F
	1	D2330-15	F
4	2	D2581	M



NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.015
REF. DART SPEC M304TS0.
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WH
- 4) TOLERANCES: PER DART QSI 018 UNLESS OT
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

RELEASED
08-09-03/11/11

ATED TO CURRENT STANDARDS.			
D. FRAME MATERIAL THICKNESS WAS		AJS	08.08.11
D D1. D2253-1 WAS D2253 (NCR 533).		KE	05.11.10
CH, REDRAWN		KE	99.09.14
AND LABEL PLATE		BK	96.05.23
DESCRIPTION		BY	DATE
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO.		REV. F	
D2330		SHEET 1 OF 6	
TITLE		SCALE	
BASKET ASSEMBLY (206B)		NTS	
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Work Order Summary

January 6, 2010 10:08:07 AM

Page 1 of 2

Criteria : Work Order ID: 45545a Item ID: D2330-043RevG Product Family LARGE FAB
 Work Order Start Dates 7/15/09 to 7/15/09 11:59:59 PM Work Order Required Dates 8/03/09 to 8/03/09
 11:59:59 PM

All References
 Work Order Status Costed

Work Order ID	45545A	Required Qty	1.0000	Status Code	Costed
Item ID	D2330-043RevG	Accepted Qty	0.0000	Scrap Qty	0.0000
Item Name	Basket Lid Assembly				
Current Acct Value	\$958.031	Sales Order ID			
Start Date	7/15/09	Required Date	8/03/09	Completed Date	12/10/09 11:21:16 AM

Standard	** Actual **		** Acct. Value **	** Variance **	** Variance % **
<u>Direct Costs</u>	<u>Total</u>	<u>Each</u>	<u>Each</u>	<u>Each</u>	<u>Each</u>
Material	\$0.000	\$0.000	\$141.497	\$141.497	100.00%
Labor	\$127.300	\$0.000	\$0.000	\$0.000	0.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$255.569	\$0.000	\$0.000	\$0.000	0.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$382.869	\$0.000	\$141.497	\$141.497	

Work Center

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
ZWIP												
6/25/09												
N/A			0.00	0.00	-0.69	-0.69	1.00	\$0.000	-\$0.690	\$0.000	\$0.000	-\$0.69
N/A			0.00	0.00	70.17	70.17	1.00	\$0.000	\$70.170	\$140.340	\$0.000	\$210.51
Total:			0.00	0.00	69.48	69.48	2.00	\$0.000	\$69.480	\$140.340	\$0.000	\$209.82

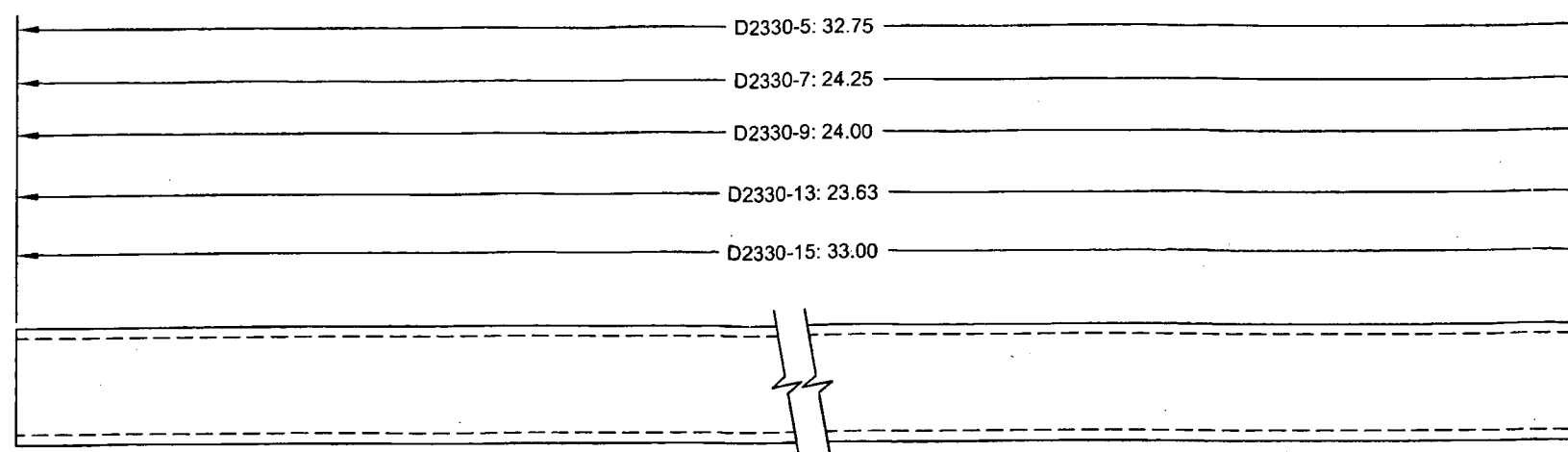
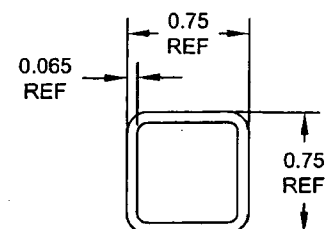
Work Center Large Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
drou02												
9/24/09												
100			0.00	0.00	0.01	0.01	1.00	\$0.000	\$0.152	\$0.303	\$0.000	\$0.45
EWER01												
10/23/09												
100			0.00	0.00	1.71	1.71	1.00	\$0.000	\$31.333	\$62.443	\$0.000	\$93.77
murd02												
11/12/09												
100			0.00	0.00	1.44	1.44	1.00	\$0.000	\$26.335	\$52.483	\$0.000	\$78.81

8 7 6 5 4 3 2 1

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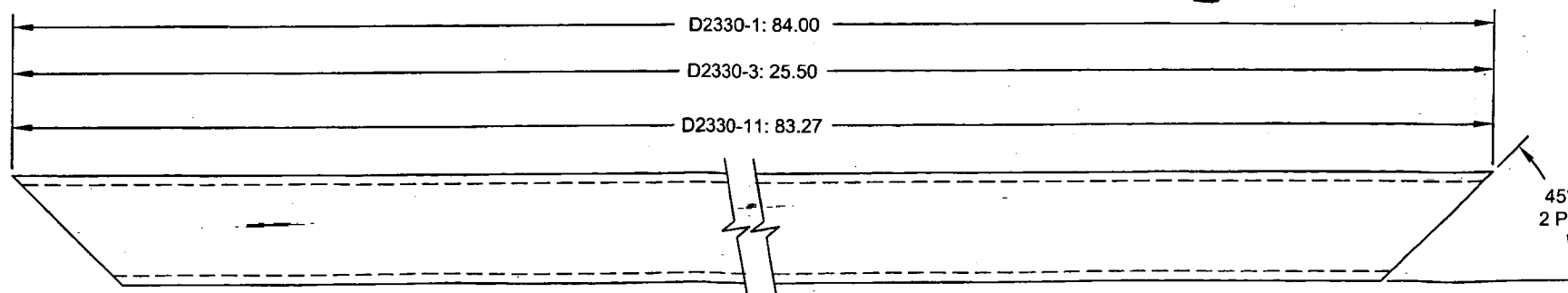
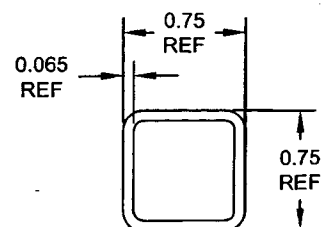
D



D2330-5 FRAME
D2330-7 FRAME
D2330-9 FRAME
D2330-11 FRAME
D2330-13 FRAME
D2330-15 FRAME

C

C



D2330-1 FRAME
D2330-3 FRAME
D2330-11 FRAME

B

B





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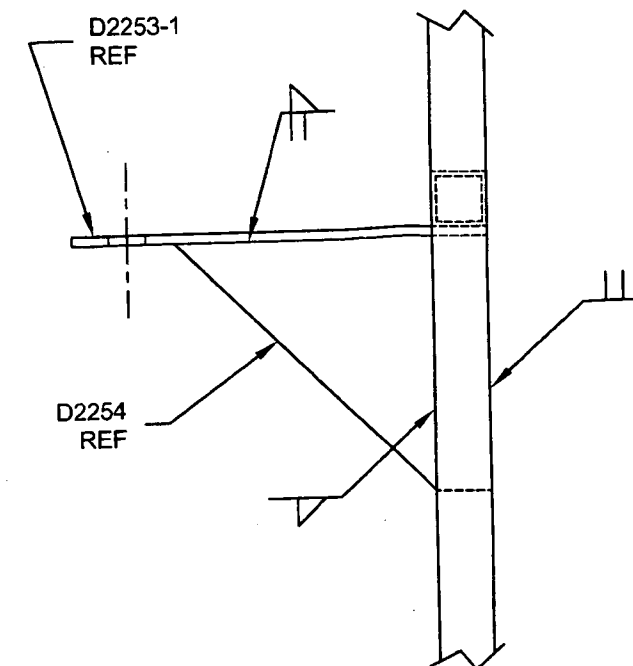
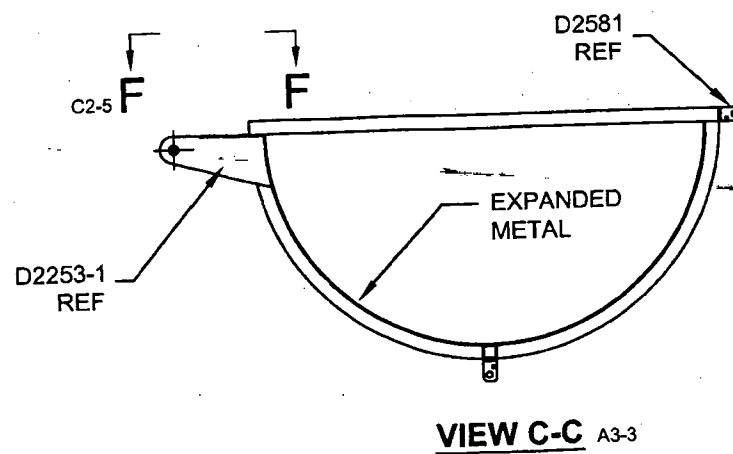
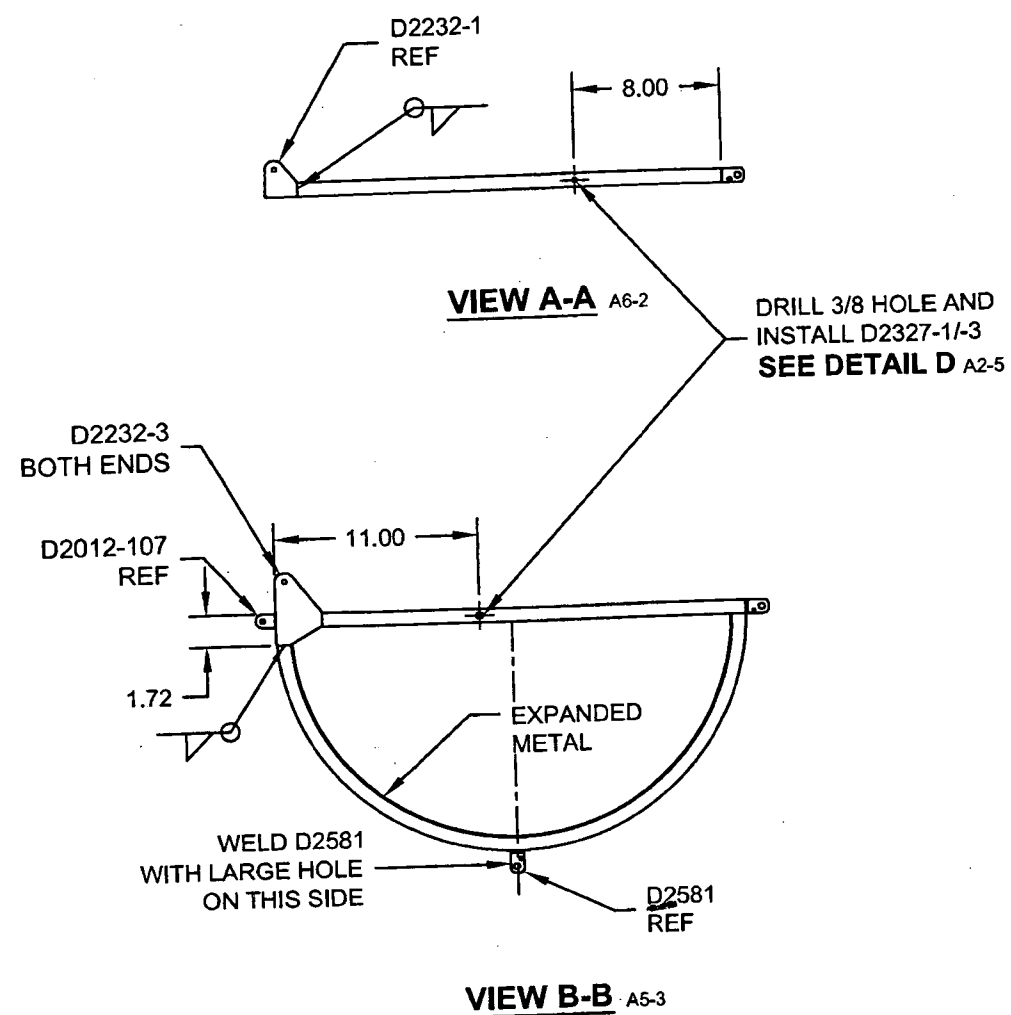
- NOTES:**
- 1) FRAME MATERIAL: SEE SHEET 1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

A

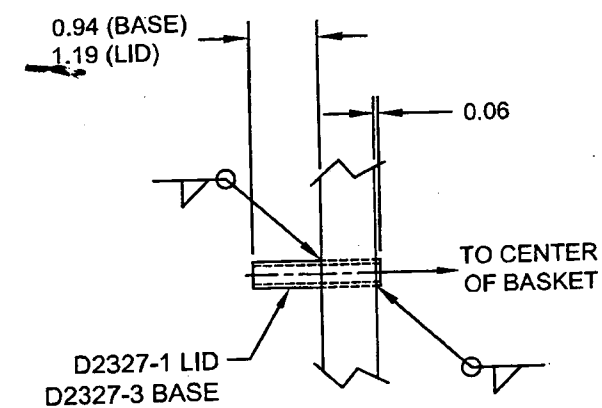
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8 7 6 5 4 3 2 1



VIEW F-F B8-5
SCALE 4X



DETAIL D
SPACER INSTALLATION
SCALE 4X

C6-2
C5-3
C6-5

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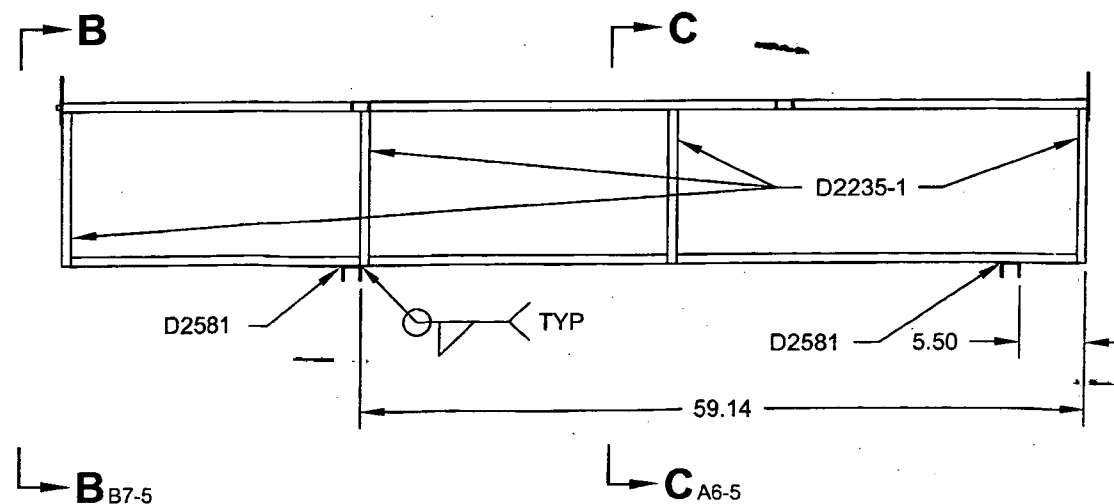
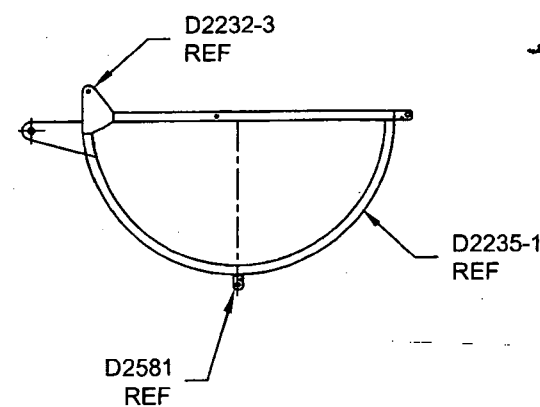
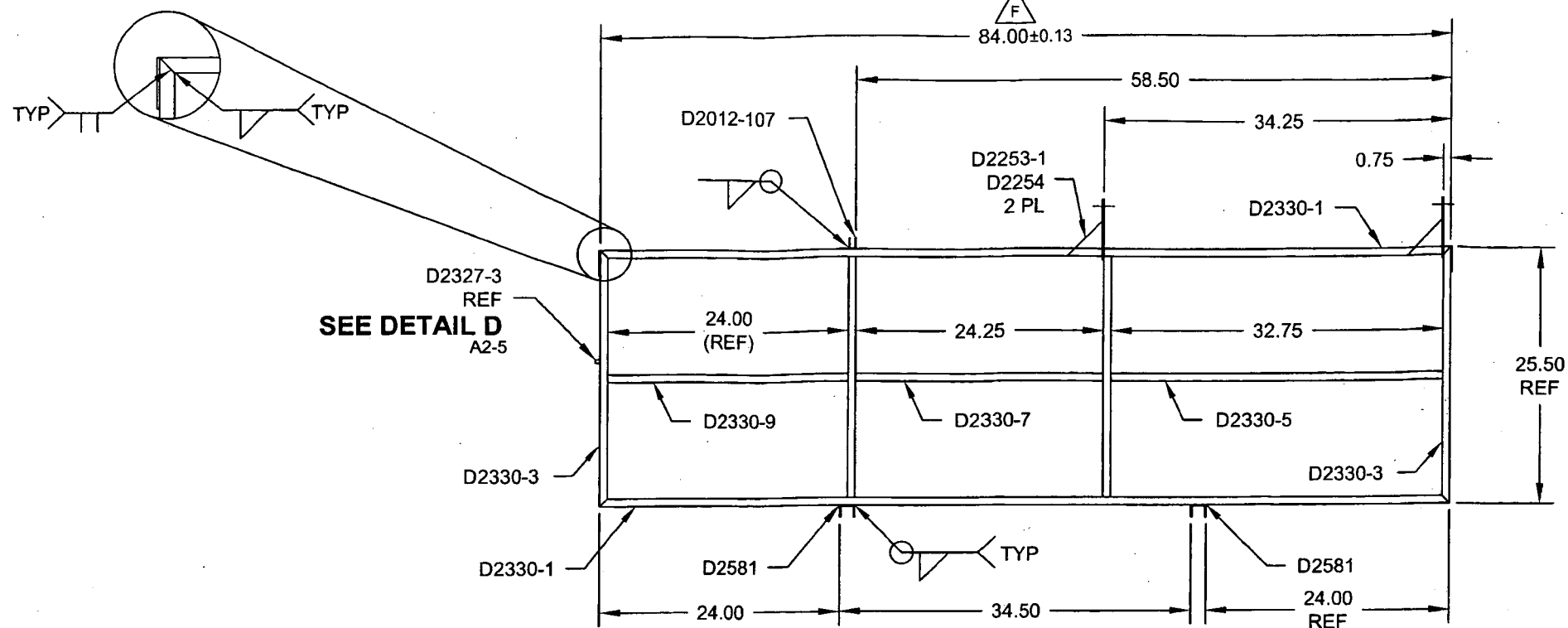
4

3

2

1

WELD ALL JOINTS
AS SHOWN



BASE FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

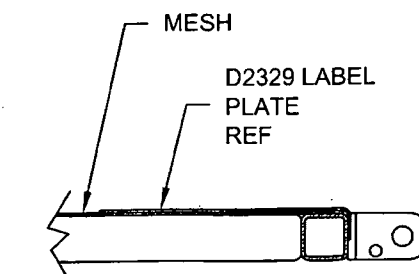
D2330-041 BASE FRAME ASSEMBLY

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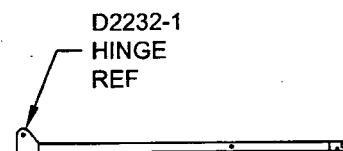
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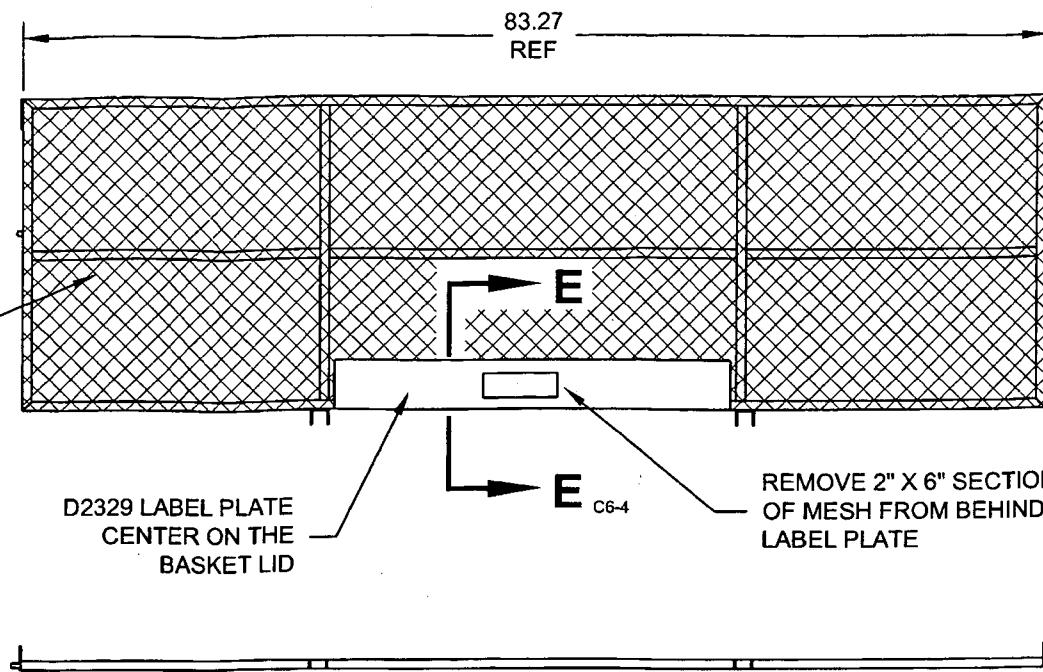
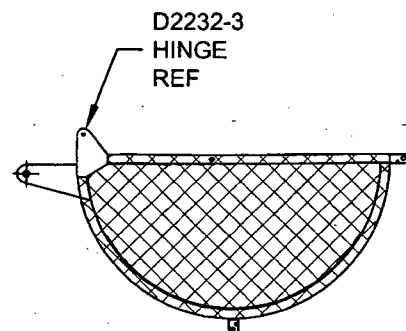
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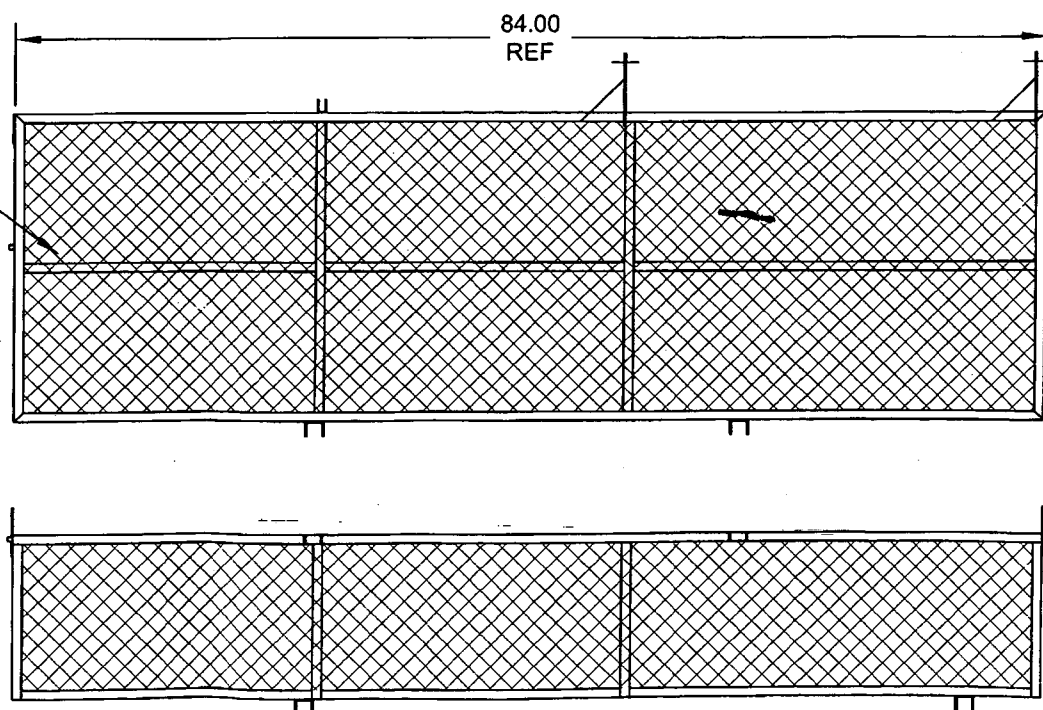
SECTION E-E C3-4
VIEW ROTATED 90° CCW



TACK WELD EACH
STRAND END OF
STEEL MESH TO FRAME







D2330-043 LID ASSEMBLY



D2330-041 BASE ASSEMBLY

ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

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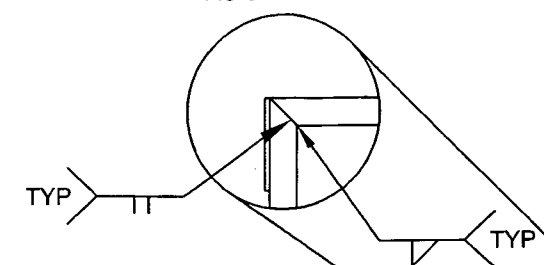
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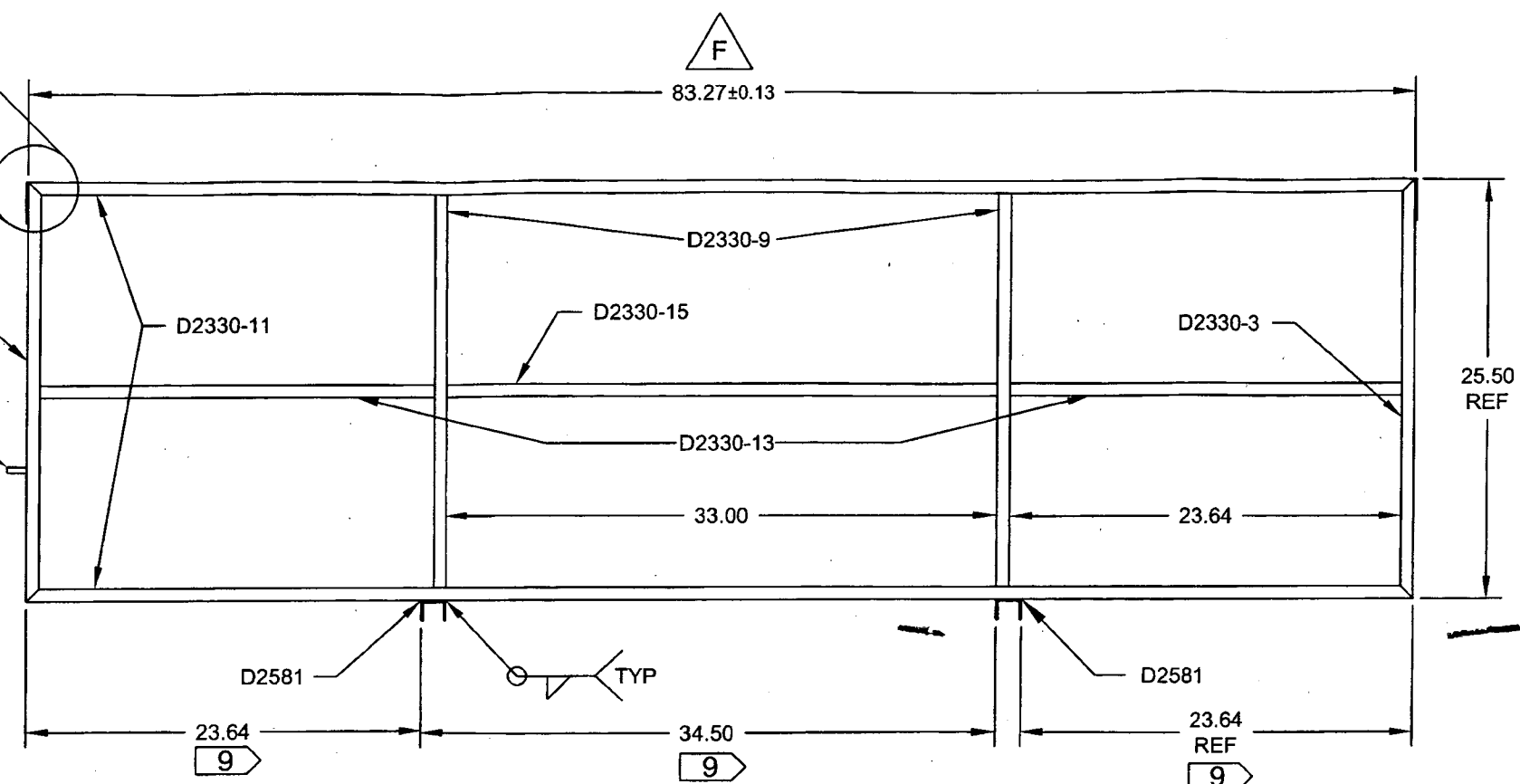
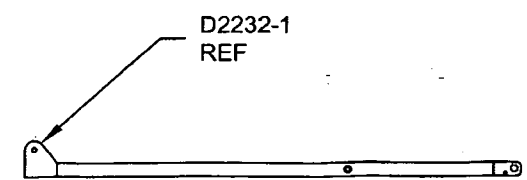
B

A

WELD ALL JOINTS
AS SHOWN



D2330-3
D2327-1
REF
SEE DETAIL D
A2-5



A
A D6-5

D2330-043 LID FRAME

- LID FRAME NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) WELD PER DART QSI 004
 - 9) ALIGN WITH ADJACENT D2581 ON BASE



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08-09-25/11

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